

is combined with a workpiece-machining device and a workpiece-storage device.

Figure 2 is a front view of the workpiece-machining facility.

Figure 3 is a side view of the workpiece-machining facility.

Figure 4 is a top view showing the general operation of the workpiece-transfer device in the workpiece-machining facility.

Figure 5 is a top view showing a suction-pad arrangement of the workpiece-transfer device.

Figures 6A and 6B are partial front and side views of the suction-pad arrangement, respectively.

Figure 7A is a top view of an advancing mechanism of the suction pad, Figure 7B is a sectional view of the advancing mechanism, and Figure 7C is an exploded view of Figure 7A as seen from direction C.

Figures 8A and 8B are explanatory drawings each showing in top view a form of material-loading operation by the workpiece-transfer device.

Figures 9A and 9B are explanatory drawings showing in top view a form of material-unloading operation by the workpiece-transfer device.

Figures 10A to 10B and 10C are explanatory drawings showing in top view another form of material-unloading operation by the workpiece-transfer device.

Figures 11A and 11B are explanatory drawings showing in top view yet another form of material-unloading operation by the workpiece-transfer device.

#### Detailed Description of the Preferred Embodiments